

536

| | | | |
|---------------------------|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 24062 |
| Description: Plug | | Part Number: | D2594-1 |
| Dwg: D2594 Rev. B1 | | Qty: | 300 |
| | | Page 1 of 1 | |

| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|------|----------|-----|
| 1 | DC | Issue Traveller | AK | 05/08/12 | 300 |
| 2 | MC | Make as per Dwg D2594-1 and Folio FA262. Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) M17807 - Batch 716807 - M18314 | S.G. | 05/10/18 | 300 |
| 3 | MC | Break all sharp edges 0.010 max. | PL | 05/10/24 | 300 |
| 4 A | QC2 | Inspect dimensions as per drawing D2594 | S.G. | 05/10/19 | 300 |
| 4 B | QC8 | Second check | En | 05/10/25 | 300 |
| 5 | FP | Acid etch and alodine as per QSI 005 4.1 | SAD | 05/11/20 | 300 |
| 6 | FP | Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary) | FC | 05/11/23 | 300 |
| 7 | QC3 | Inspect Powder Coat | MM | 05/11/24 | 300 |
| 8 | FP | Identify and Stock | MM | 05/11/24 | 300 |
| 9 | AC | Cost / part | JUR | 05/11/25 | 300 |
| 10 | DC | Close W/O Inspect Level 21 | LP | 05/11/25 | 300 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|--|------------|----------|
| A | 98.11.27 | New Issue | DM | |
| B | 00.11.01 | Removed P/O for Powder Coat – in house process | EC | |
| C | 01.07.17 | Reformat step 2 | SM | |
| D | 02.08.22 | Make in Cobra | KJ RF | AK |

RELEASED
02/08/22 RF

RF
02/10/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/25

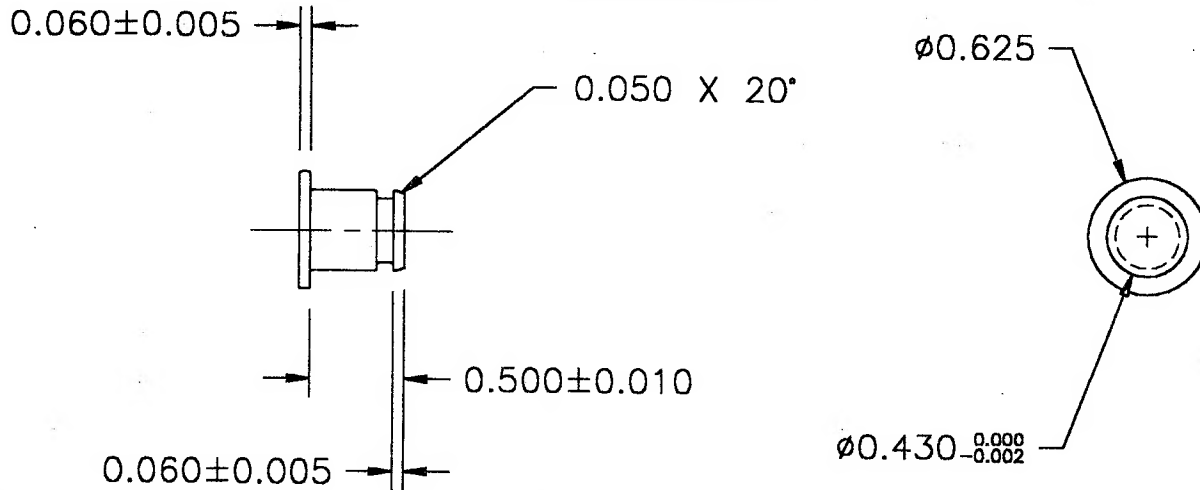
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



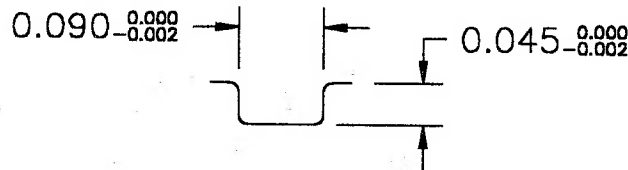
| | | | |
|------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>BW</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2594 | REV. B SHEET 1 OF 1 |
| DATE 96:09:16 | | TITLE PLUG | SCALE 1:1 |
| B | 97:03:15 | ADD GROOVE AND O-RING | |
| B1 | RF 02.08.26 | ADD POWDER COAT, QSE 018, & QQ-A SPECS. | |

D2594-1 PLUG:

RELEASED
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOLERANCES ARE PER DART QSE 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.5.1) PER QSE COS 4.3

PER QQ-A-225/7 (5052)
OR QQ-A-225/8 (6061)
OR QQ-A-225/1 (1100)
OR QQ-A-200/8 (6061)



SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG WORK ORDER
(1) D2594-3 O-RING

NO. 24062

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 11, 2005
01:37 pm

Work Order No : 0024062
Project Name : D2594-1
Project For : WK536
Work Order Type : Main
Main WO Number :
House Part Number : D2594-1
Description : Plug
Manufactured : Yes
Amount Req'd : 300
Amount Done : 0
Start Date : 08-11-05
Est Finish Date : 09-04-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Mark up : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | | |
|--------------------------|-----------|--------|
| | Estimated | Actual |
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/(Loss) : | 0.00 | 0.00 |